

SPECIFICATION AMENDMENTS

The replacement paragraph at page 12, line 21 through page 13, line 9 is as follows:

37 A molten metal pouring unit 15, which can be freely swung around a supporting shaft 14, is provided below both the molds 11, 12. The molten metal pouring unit 15 has a plunger 17 freely reciprocating in an injection sleeve 16 and the plunger 17 is driven by a pressure cylinder 18. When a preform is case by the use of the high pressure casting apparatus 10, molten metal 19 is supplied into the injection sleeve 16 and then the one mold 12 is moved near to the other mold 11 and at the same time the molten metal pouring unit 15 is swung so that the injection sleeve 16 is linear with respect to the mating surface 20 of the mold. Further, the injection sleeve 16 is moved nearer to both the molds 11, 12 and then the pressure cylinder 18 is driven to pour the molten metal into the cavity of the molds 11, 12 at a pouring speed of 30 cm/sec.